On-Site Operating Manual for Nitrile/Latex/PVC Glove Production Line

Fengwang has 20 years of experience in glove production processes and machinery, specializing in all aspects of glove manufacturing and troubleshooting production line issues. Below is our summarized On-Site Operating Manual for Glove Production Lines.

1. Startup Procedures and Key Notes

During the heating process, designated personnel must inspect each section of the production line. Once temperature and other parameters meet requirements, the assigned operator will initiate the dipping process and manage the horn bend of the material tank. Dipping must only begin after all operators are in position.

Note: To avoid errors, the same operator must handle both the dipping process and the horn bend adjustment—this is critical.

Next, equipment startup must be performed simultaneously by designated personnel. Supervise the entire production line and report any abnormalities immediately.

2. General Incident Handling Guide

Operators must assess whether a shutdown is necessary.

Note: Do not power off directly—use the rotary stop switch.

(1) Equipment failure:

Assign personnel to remove gloves already on the hand molds.

Assess the extent of damage before deciding on further actions.

(2) Production line jam:

Treat as a major incident and assign personnel before troubleshooting.

3. Major Incident Handling Guide

For severe failures, assign dedicated personnel to each station:

(1)Shut down the boiler (1 person).

(2)Open oven doors (2 persons).

(3)Loosen the counterweight trolley nut (1 person).

(4)Troubleshoot the issue (4 persons):

(5)Check the head return wheel position (1 person).

Inspect other return wheels, trolleys, material tanks, edge rollers, etc. (remaining personnel).

Lift the edge roller, disengage the demolding clutch, and reduce startup load.

(6)Prepare tools (1 person):

Maintain a spare parts inventory (list required) in a dedicated storage room with in/out records.

(7)Halt production safely:

Mark hand molds (e.g., with bright tape) before racking.

Rack molds at the material tank based on markings.

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After completing these steps:

Start the line slowly (1 person) while others monitor and communicate via radio.

Address the issue promptly:

Remove gloves from the oven first.

Decide whether to restart the edge roller based on glove condition.

After clearing the line, allow temperatures to drop before repairs.

Replace severely yellowed/stuck hand molds and clean them per 《Hand Mold Cleaning Guide》.

4. Shutdown Precautions

Before shutdown:

(1)Assign tasks to designated personnel.

(2)The racking operator must also manage the material tank's horn bend.

(3)Confirm no gloves remain on the line before:

Stopping equipment.

(1)Opening oven doors.

(2)Loosening the counterweight trolley nut.

Note:

(1)Shutdown only after all operators are in position.

(2)Strictly prohibit cross-role operations to minimize errors and losses.

Additional Maintenance Notes

1. Daily Checks:

(1)Inspect equipment operation.

(2)Clean the main unit, return wheel shafts, dust trays, edge rollers, powder removal chamber, demolding area, and material tank surroundings.

2. Lubrication & Maintenance:

Main rail: Lubricate every 3 days; deep-clean monthly (use a drag mop for chain/mold seat sludge).

Auxiliary rail (horn bend): Clean daily.

3. Daily Cleaning:

Smoke collection zones & return wheels: No oil buildup, debris, or broken molds.

Shafts/bearings/dust trays: Oil- and dust-free.

4. Demolding Area:

Clean floors every 2 hours (no dust, debris, or gloves).

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5. Material Tank (Including PU Tank):

Remove insects, foreign objects, and sediment hourly.

Clean recycle tank-to-oven areas every 2 hours.

6. Pre-Demolding Machine:

Daily cleaning (oil-free motors/surfaces).

7. Exhaust Treatment System:

Daily cleaning (oil-free floors, dust-free motors/fans/windows).

8. Production Line Pathways:

9. Clean daily.

Shared Areas (Break Rooms, Locker Rooms) & Surroundings: Assign rotating shifts for cleaning.

Note: This manual ensures minimized downtime, optimized safety, and extended equipment life. Strict adherence is mandatory.

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